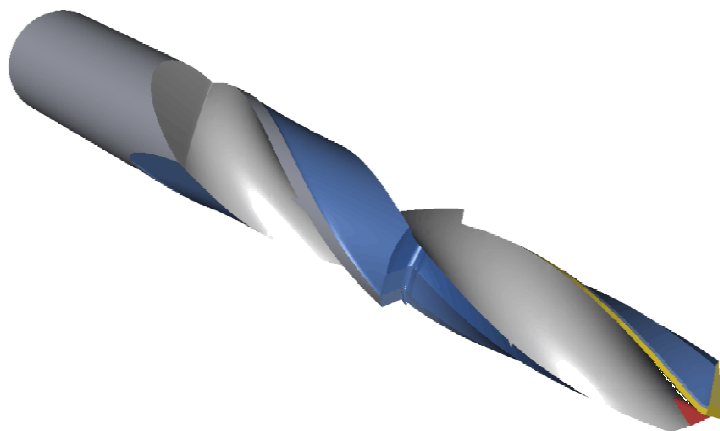


## Profiled Step Drill Ø12 Ø8

**A02-001**

The Profiled Step Drill was ground from solid blank Ø12mm.



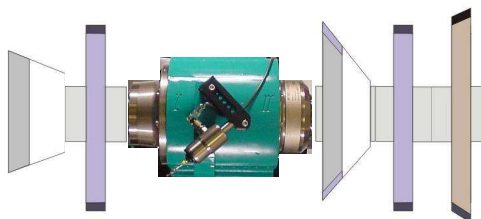
### 1. Cycletime for Production

<b>Workpiece:</b> Diameter 12 mm, Z 2, Length of cutting edge 54 mm, Helix angle 30° Material CARBIDE										
<b>Operations</b>										
Feed [mm/Min]	2000	60	80	125	50	70	50	70	10	70
Power [kW]		3	2	1	1	1	1	1	1	1
Cutting speed [m/s]		19	22	22	22	22	22	22	22	22
<b>Used wheels</b>										
Grinding time [s]	9	168	33	72	34	27	322	236	213	122
<b>Total cycle time</b>	20 Min 36									

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø100 D64
4	1V1 Ø125 D64
5	1A1 Ø125 D64



3 5

2 1 4

### 3. Machine and Software Requirements

**Machines:** 5 axes CNC grinders : GEMINI DMR      **Coolant:** Synthetic Oil, pressure 6 bar  
**Control:** Fanuc 31iA5      **Software:** Quinto 5  
**Accessories:** AWL 8

Responsible engineer: OP. 16.11.12

**www.schneeberger.ch**

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